

delns 3hr

Work Order ID 144670-1

144670

Page 1

April 21, 2016 3:15:27 PM

Split - 1

Item ID: D2618

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 5/4/2016 Start Qty: 100.00

100

5 SH

Cust Item ID:

Required Date: 5/19/2016 Req'd Qty: 100.00

100

5

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: APR 22 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2618

Rev B1

100

0.58

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

6.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA195 & Dwg D2618.2-Deburr

5

0

DAS

45

9-89

20165-2

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

1.00

Quality Control

5

0

DAS

45

9-8

20165-2

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

2.00

Quality Control

5

0

DAS

14

9-89

16/05/02

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 144670

144670

Page 2

April 21, 2016 3:15:27 PM

Item ID: D2618 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bushing
 Start Date: 5/4/2016 Start Qty: 100.00 *100* Cust Item ID:
 Required Date: 5/19/2016 Req'd Qty: 100.00 *100* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>SA</u>	0.00							
	Memo	1.00							5x SP/6-05-2
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	10.00							MLJ MAY 02 2016

SA 20160502

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

April 21, 2016 3:15:27 PM

Page 1

Work Order ID: 144670

144670

Parent Item: D2618

D2618

Parent Item Name: Bushing

Start Date: 5/4/2016

Required Date: 5/19/2016

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP Rev:F Re-format 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR0.750		Purchased		No		100	f	70.1460	0.258	27.15789			

MDFI RINR0 750

Delrin Round Bar 0.75" color: black

Location

Loc Qty

Loc Code

MAT039

70.146

m134281

6.146

m134549

64

1.6

DAS

45

9-89

2016-5-2

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

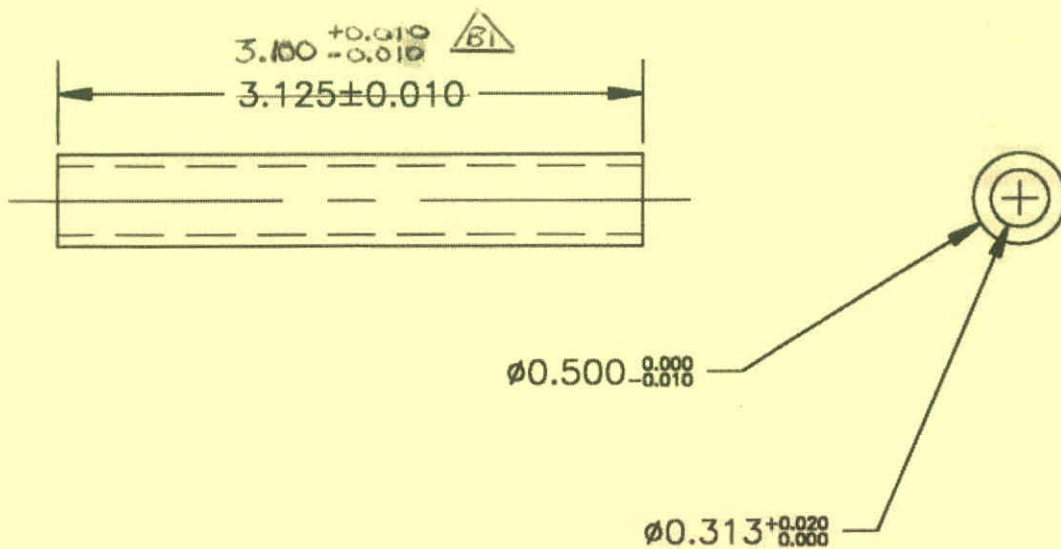
Work Order update only ☐

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DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2618	REV. B SHEET 1 OF 1
DATE 96:10:30		TITLE BUSHING	SCALE 1:1
B	97.05.09	3.125 WAS 1.625, .313 WAS .375	
B1	04.06.03	CHANGE DIM FOR BETTER FIT	

RELEASED
91/05/13 DS



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